



Dart Aerospace Ltd.
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647.1404
Job Sheet 204989



Part No: 647.1404

Part Name: Upper Cutter Assembly

Part Weight: 0 lbs

Job Created: 12/23/19

Due Date: 3/6/20

Type: ~~Stock~~ *Sold*

Note: DWG 647.1400 REV E IPP REV:A 16.03.28 NEW ISSUE DD VERF:JLM

Ship Via:

Job Qty: 6 pcs

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	6 pcs		3/6/20	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		



Container No: S245514



Part: 647.1404
Job No: 204989
Serial No/Batch: S245514

Revision: E
Inspector:
Exp Date:
Instructions: Various STC's

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CANADA
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Date: 01/07/20

DAS
41 JAN 04 2020
9-89

120	Small Fab - 2 - B4B	6 pcs	3/6/20	0.00 2.51	Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					Packaging 1 - 37	
					Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	DAS 41 JAN 07 2020
					Small Fab - 7 - B4B	2-89
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
130	QC 5	6 pcs	3/6/20	0.00 0.00	Small Fab - Various 1 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS JAN 08 2020 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140	Packaging 3-1 - Stock - B4B 6 pcs		3/6/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	DAS CC5048 80 9-89
					Packaging 3 - 4 - B4B	JAN 10 2020
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
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					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
	150 QC 21 - SA	6 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21 ✓ cck048

QC 21 - SA - 70	DAS
QC 21 - SA - 53	21 JAN 10 2020

Part Op 110 - (Pick Kit)
Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.A/R RTV LOCTITE
598: 524075 exp. date: 1/21
130 - (QC5- Inspect part completeness to step on W/O)
140 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
150 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
646.9703	Cutter Sub Assembly	6 pcs (1 ea)	110-Packaging 1 - Pick Kit	<u>5244229</u>
647.1513	Upper Deflector	6 pcs (1 ea)	110-Packaging 1 - Pick Kit	<u>5118028</u>
MS21042L08	Nut	18 Ea (3 ea)	110-Packaging 1 - Pick Kit	<u>5231236</u>
MS27039-08-19	Screw	18 Ea (3 ea)	110-Packaging 1 - Pick Kit	<u>5231293</u>
NAS1149FN832P	Washer (AN960-8)	36 Ea (6 ea)	110-Packaging 1 - Pick Kit	<u>5235228</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.9703	6	4	0
	647.1513	6	17	0
	MS21042L08	18	794	0
	MS27039-08-19	18	842	0
	NAS1149FN832P	36	1,652	0

Part Specifications				
Specifications could not be found.				

NCR No.

Job: _____		DISPOSITION		DEPARTMENT/PROCESS		Route update only	
Part No. _____		Rework Scrap Use-as-is		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	
Date :		Sequence #:		QTY Affected :		MR8 (QS1042)	
Description Work Order Deviation				Disposition			
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			